

Date: Wednesday, 13/06/2007 3:15:37 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GASKET
Job Number : 32905	
Estimate Number : 12714	
P.O. Number : N/A	Part Number : D353639
This Issue : 13/06/2007 S.O. No. : N/A	Drawing Number : D3536 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 32414	Material : N/A
Written By : _____	Due Date : 20/06/2007 Qty: 20 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 07-02-14 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MNEO60S063	NEOPRENE SHEET 0.063
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Comment: Qty.: 0.7911 sf(s)/Unit Total: 15.8214 sf(s)

NEOPRENE SHEET 0.063

Batch: M103104

SAD 07/06/14

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3536

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

SAD 07/06/14

20 (R0)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/14

20

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

SAD 07/06/14

Y20

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1


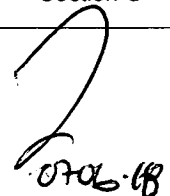
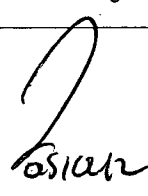
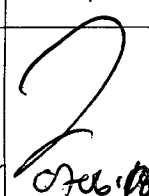
Identify and Stock

Location: _____

SAD 07/06/14 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/17	2.0	2 part were Scrap because the Neoprene was at the end of its roll and had too many waves in the material and need more weight on top when cutting on the waterjet to stretch it out. "Part were too long in length"		Scrap, destroy, replace Put more weight on top of material to stretch out wave in the mat <u>Pay Attention to the machine operation.</u>	SAD 07/06/17			

NOTE: Date & initial all entries

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Process Sheet

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Drawing Name: GASKET

Job Number: 32905

Part Number: D353639

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten signature

Job Completion



Handwritten signature

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

TRANSMISSION VERIFICATION REPORT

TIME : 06/12/2007 15:48
NAME : DART AEROS
FAX : 6136321053
TEL : 6136329577
SER.# : BROL2J813781

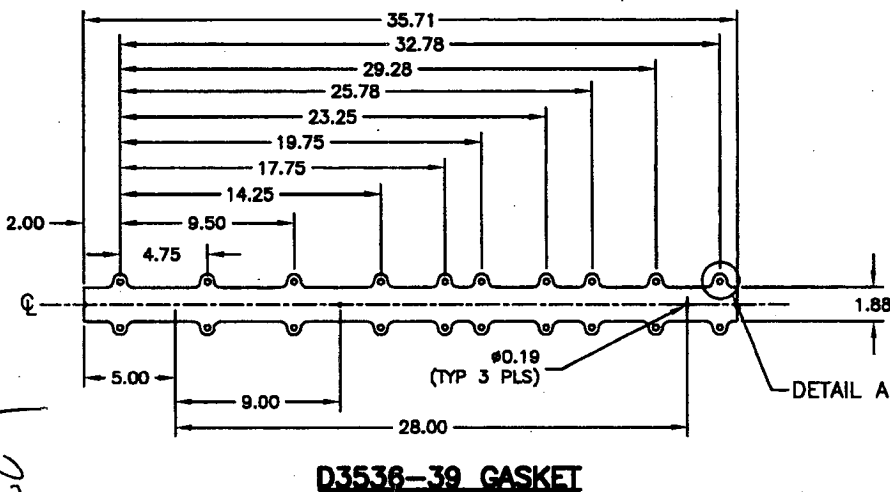
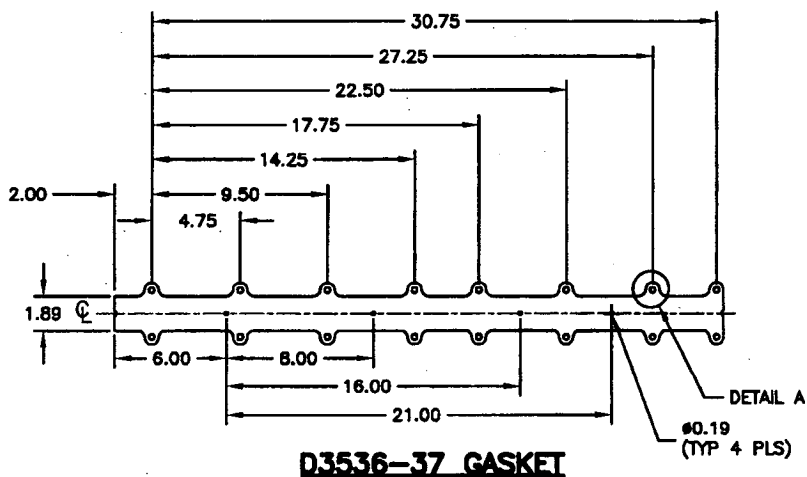
DATE, TIME	06/12. 15:48
FAX NO./NAME	101594516042741013
DURATION	00:00:00
PAGE(S)	00
RESULT	BUSY
MODE	STANDARD

BUSY: BUSY/NO RESPONSE

DART

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 5 OF 6
				SCALE 1:10

07.02.02 CH



NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W1032905

DART AEROSPACE LTD		Work Order: 32905
Description: Gasket		Part Number: D3536-39
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
35.71	+/-0.030	35.74	✓		M-T	
32.78	+/-0.030	32.80	✓		Vern M-T	
29.28	+/-0.030	29.28	✓		M-T	
25.78	+/-0.030	25.78	✓		M-T	
23.25	+/-0.030	23.28	✓		M-T	
19.75	+/-0.030	19.78	✓		M-T	
17.75	+/-0.030	17.76	✓		M-T	
14.25	+/-0.030	14.29	✓		M-T	
9.50	+/-0.030	9.50	✓		M-T	
4.75	+/-0.030	4.75	✓		M-T	
5.00	+/-0.030	5.00	✓		M-T	
9.00	+/-0.030	9.00	✓		M-T	
0.30	+/-0.030	0.31	✓		Vern	
0.30	+/-0.030	0.30	✓		Vern	
1.88	+/-0.030	1.88	✓		Vern	
Ø0.19	+0.005/-0.001	0.20	✓		Vern	
0.063	+/-0.010	0.062	✓		Vern	

Measured by: SAJ	Audited by: CM	Prototype Approval:	N/A
Date: 07/06/14	Date: 07/06/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	